

Work Order ID 138068

138068

Page 1

Thursday, October 22, 2015 11:35:13 AM

Item ID: D3916-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Rib Assembly
 Start Date: 10/22/2015 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 10/22/2015 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: MLS Date: OCT 22 2015 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3916	A

100 0.00
 100
 Large Fab
 Large Fab
 Memo
 1- Cut tube 50"
 2- Bend tube with manuel pipe bender as per DT9567
 *** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***
 3- Trim access tube material to finish size as per dwg D3916
 4- Drill and chamfer holes as per dwg D3916-1 using DT9605

4x CC 15-11-4

105 QC6- Inspect dimensions to drawing 0.00
 105
 QC Memo 0.00
 Quality Control

4x NOV 04 2015 DAS 24 9-00

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138068

Page 2

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Required Date: 10/22/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
107	Weld per dwg A/R S.S. rod Batch: <i>B132768</i>	0.00							
107									
Large Fab	Memo	0.02							
Large Fab	1- weld bushing as per dwg D3916 2- grind welds flush								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC10- Inspect visual per QSI004- ground welds	0.00							
120									
QC	Memo	0.00							
Quality Control									

4x CC 15-11-4

4 **NOV 04 2015** **DAS 24 9-89**

4 **NOV 04 2015** **DAS 24 9-89**

Work Order ID 138068

Thursday, October 22, 2015 11:35:13 AM

138068

Page 3

Item ID: D3916-041 Accept ***N900040100*** Setup Start ***NS1***
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Required Date: 10/22/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>WA 4</u>	0.00				<u>4</u>		NOV 04 2015	DAS 24 9-89
130									
Packaging	Memo	0.00							
Packaging	LOCATION: WA004								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.01							
Quality Control									

MLJ NOV 04 2015

MLJ NOV 04 2015

Picklist Print

Thursday, October 22, 2015 11:35:19 AM

Page 1

Work Order ID: 138068

138068

Parent Item: D3916-041

D3916-041

Parent Item Name: Rib Assembly

Start Date: 10/22/2015

Required Date: 10/22/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1		Manufactured	No			100	Each	116.0000	7	28			

D3759-1

Bushing

16 15-11-4

Location

Loc Qty

Loc Code

WA004

116

135756

1

136430

15

137117

100

M304TS0.750W.049

Purchased

No

100

f

1,211.858

4.166

17.54105

M304TS0 750W 049

304 SQ Tube .75x.75x.049W

16 15-11-4

Location

Loc Qty

Loc Code

WA004

1211.858768

M131868

26.436368

M132744

285.4224

M133163

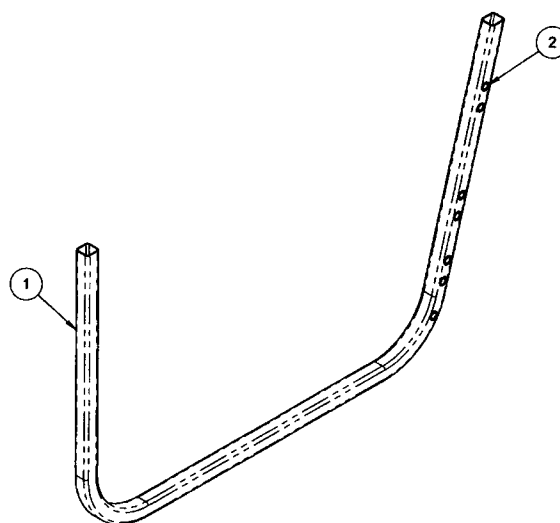
600

M133417

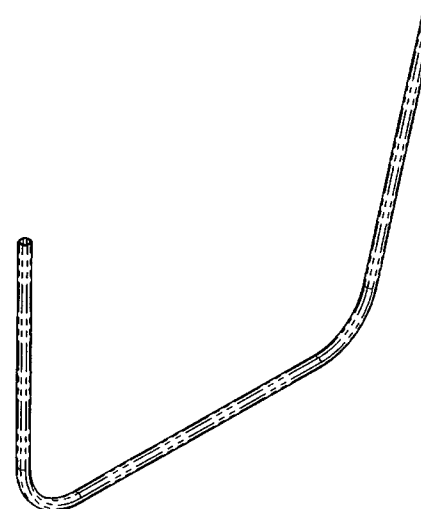
300

18.

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



D3916-041 RIB ASSY



D3916-5 LIGHT RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 138068 M.S

15-10-22

UNDER REVIEW

10.10.04

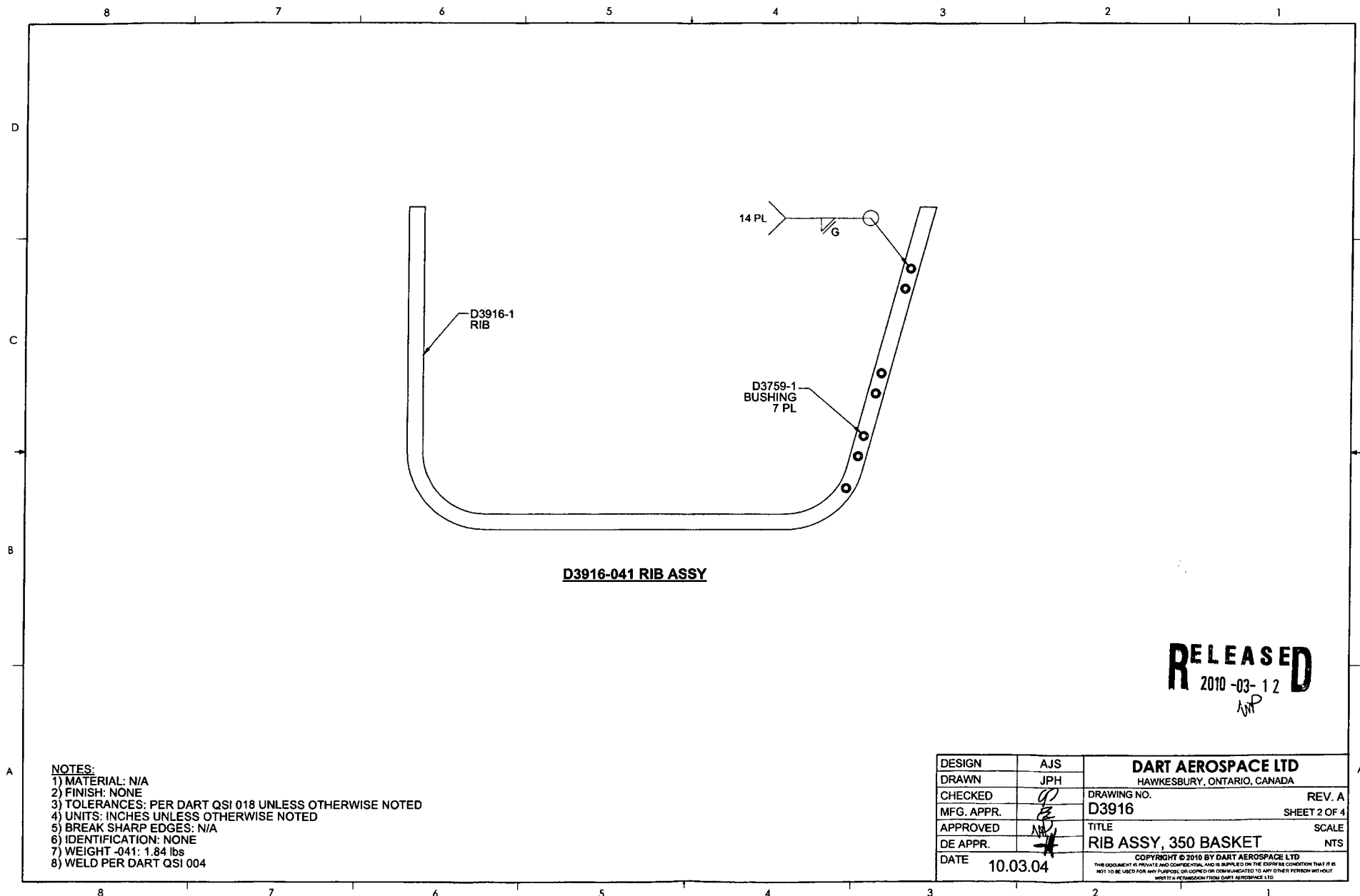
ADDITION OF HOLE + BUSHING
ON D3916-041 RIBS.

RELEASED

2010-03-12

MP

A		NEW ISSUE		JPH		10.03.04	
REV.		DESCRIPTION		BY		DATE	
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				REV. A	
DRAWN	JPH					SHEET 1 OF 4	
CHECKED		DRAWING NO.		D3916		SCALE	
MFG. APPR.		TITLE		RIB ASSY, 350 BASKET		NTS	
APPROVED		DATE		10.03.04		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3916-041 RIB ASSY

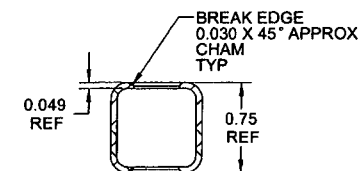
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004

RELEASED
2010-03-12
AMP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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9 D3916-1 RIB



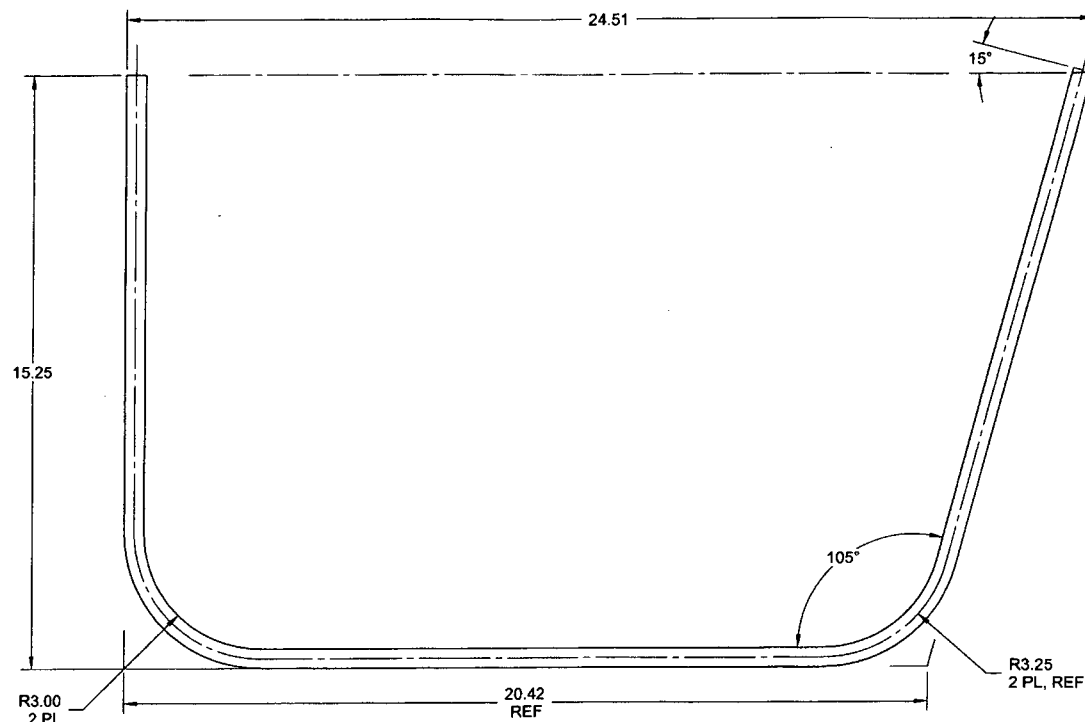
SECTION A-A

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.76 lbs
- 9) TUBE FLAT LENGTH 50.0 REF

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3916	REV. A SHEET 3 OF 4
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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DATE	10.03.04		



9 D3916-5 LIGHT RIB

RELEASED
2010-03-12
JW

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3916	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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